

Work Order ID 151490

Tuesday, September 27, 2016 11:54:31 AM

151490

Page 1

Item ID: D3319-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Full Length Wearplate
 Start Date: 9/15/2016 Start Qty: 8.00 ***8*** 10 ***8*** 10
 Required Date: 9/27/2016 Req'd Qty: 8.00 ***8*** 10 ***8*** 10
 Cust Item ID:
 Customer:
 Reference:

Approvals: Process Plan: **DAS** 21 Date: **SEP 28 2016** Tooling: Date: Run Start ***NR1***
 QC: **9-89** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.24							
FLOW CNC Waterjet	1-Cut as per Dwg D3319								
	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.01							
Quality Control									

(10) _____ ac 16/09/30

(10) _____ ac 16/09/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				<u>10</u>			DAS 38 9-89 SEP 30 2016
140 *140* Brake NC Brake NC	NC BRAKE Memo Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>C</u>	0.01 0.07				DAS 30 9-89 <u>10</u>			OCT 06 2016
150 *150* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>10</u>			DAS 38 9-89 OCT 07 2016

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab	Weld per dwg A/R Hardcoat steel Batch: <u>M125425</u> Large Fab	0.00				(10)			
	Memo	0.39							Dye/CR 10/10/27
Large Fab	Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Batch A/R 7560 Hardcoat Rod <u>M125425</u>								
170 *170* QC	QC10- Inspect visual per QSI004- ground welds	0.00				10			DAS 38 9-89
Quality Control	Memo	0.00							OCT 31 2016
180 *180* QC	QC5- Inspect part completeness to step on W/O	0.00				10			DAS 38 9-89
Quality Control	Memo	0.03							OCT 31 2016

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>on 134858.</i> Memo START TIME: <u>2:15.</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>2:45.</u>	0.00 0.03				<u>10</u>	<u>0</u>	<u>16-11-01.</u>	<i>23 34 9-89</i>
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>(10)</u>			<i>DAS 38 9-89</i> NOV 03 2016
210 *210* Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following:TCCA-PDA, Dart Aerospace Ltd.P/N: D3319-3, B/N: BXXXXXXFor Product Eligibility see PDA05-18 and Stock Location: <u>512601A</u>	0.00 0.00				<u>10</u>		<u>NOV 24 2016</u>	<i>DAS 6 9-89</i>

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

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NOV 24 2016

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		OTHER : ☐							

Picklist Print

Tuesday, September 27, 2016 11:54:31 AM

Page 1

Work Order ID: 151490

151490

Parent Item: D3319-3

D3319-3

Parent Item Name: Full Length Wearplate

Start Date: 9/15/2016

Required Date: 9/27/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: A05.05.12New issueKJ/JLM
IPP Rev:B Now on Waterjet 06-10-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased		No		100	sf	73.8042	3.2524	27.38863			

M1010S18GA

1010/1025 SHEET .048

see 116/09/30

Location

Loc Qty

Loc Code

MAT019

73.804152

124428

3

m130454

0.3542

m132886

10.45

m134083

10.7

m134982

12.3

m135612

37

27

DQA: _____ Date: _____

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

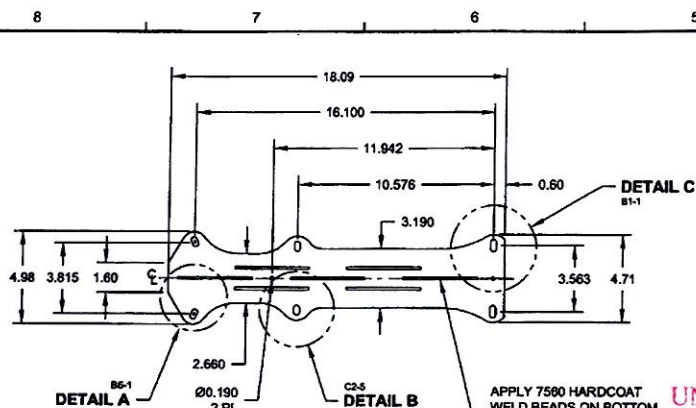
DART AEROSPACE LTD		Work Order:	151490
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

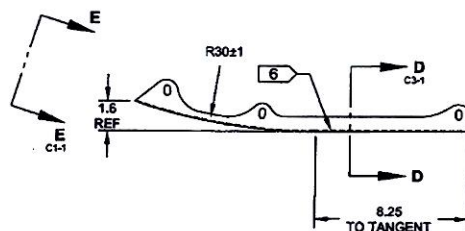
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.190	+0.005/-0.001	Ø.190	1		V.D.-02	
Ø0.500	+0.006/-0.001	Ø.501	1		V.D.-01	
0.316	+/-0.010	.315	1		Tap	
0.607	+/-0.010	.604	1			
2.94	+/-0.030	2.949	1			
2.69	+/-0.030	2.899	1			
3.527	+/-0.010	3.526	1			
4.52	+/-0.030	4.523	1			
5.063	+/-0.010	5.064	1			
6.16	+/-0.030	6.168	1			
0.60	+/-0.030	.604	1			
8.690	+/-0.010	8.691	1			
30.790	+/-0.010	30.790	1			
52.88	+/-0.030	52.88	1			
62.770	+/-0.010	62.770	1			
74.420	+/-0.010	74.420	1			
75.52	+/-0.030	75.52	1			
0.050	+/-0.010	.046	1			

Measured by:	de	Audited by:	DAS 38 289	Preliminary Approval:	
Date:	16/09/30	Date:	SEP 30 2016	Date:	

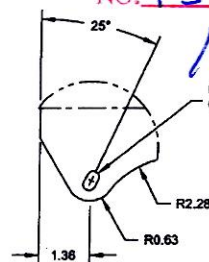
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	
B	12.05.15	Dimensions updated per Dwg Rev C	KJ	



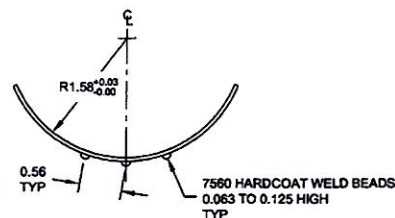
D3319-1F FLAT PATTERN



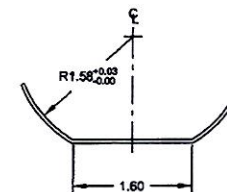
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



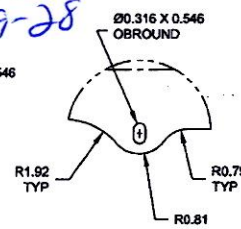
DETAIL A
SCALE 4X



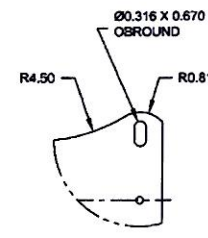
SECTION D-D
SCALE 4X



SECTION E-E
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEXT (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

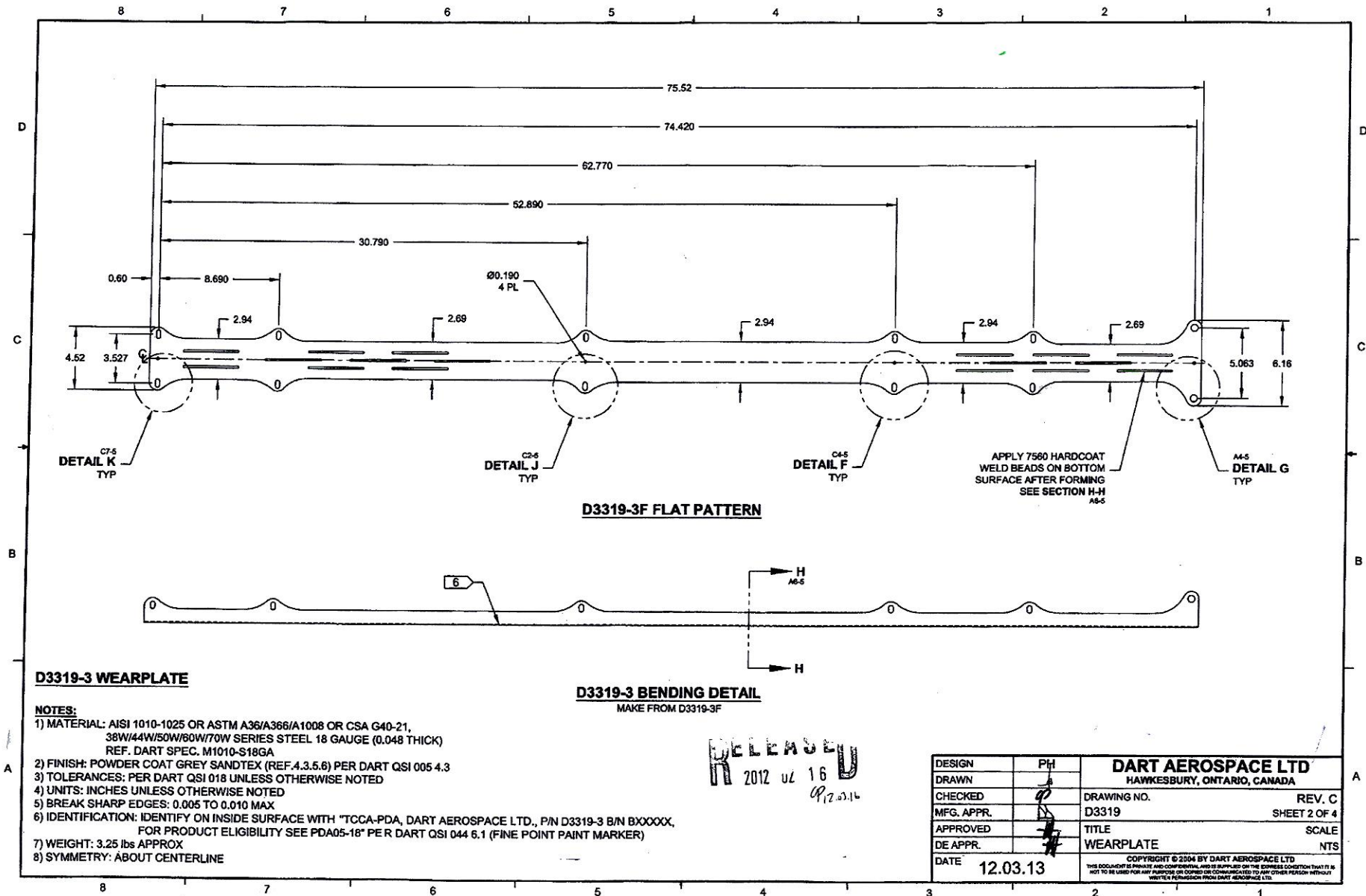
RELEASED
2012-03-16
PER ECN 12-946 12.03.16

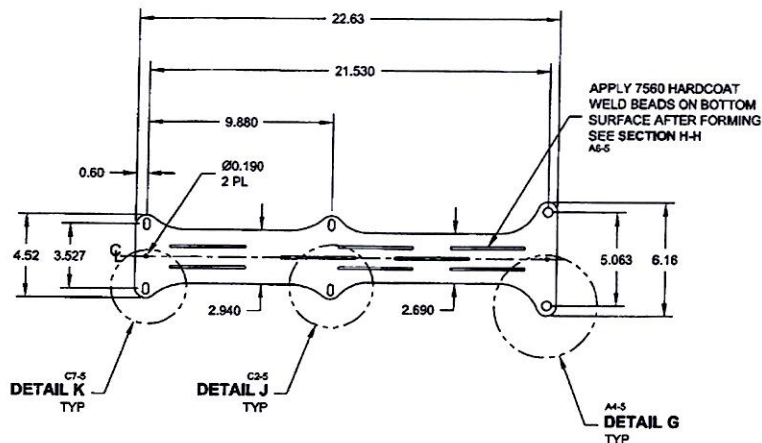
C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT MOST HOLE ON -3/5-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.03.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

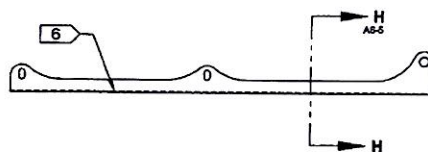
DRAWING NO. D3319
TITLE WEARPLATE
REV. C
SHEET 1 OF 4
SCALE NTS

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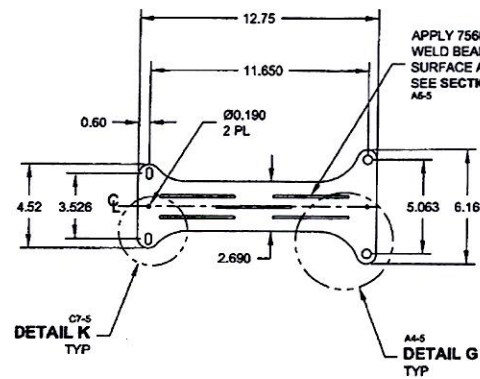




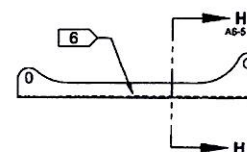
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

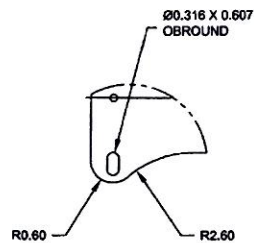
D3319-5/-7 WEARPLATE

NOTES:

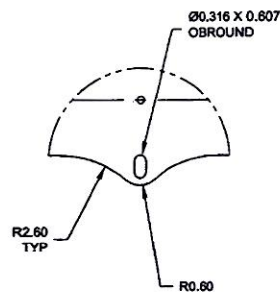
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16
42.0316

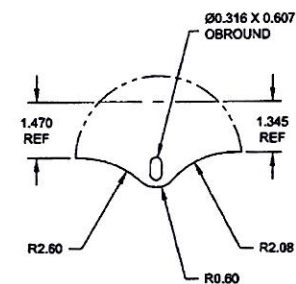
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. C
CHECKED		D3319	SHEET 3 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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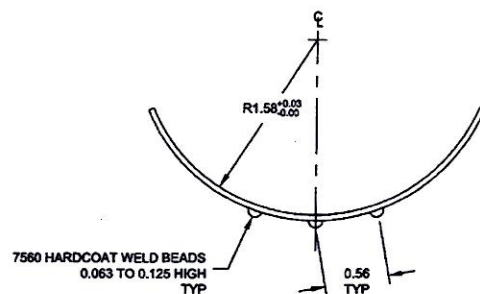
DETAIL K
SCALE 2X
B6-2
C4-3
C8-3



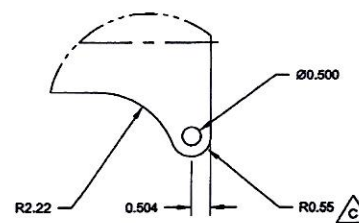
DETAIL F
SCALE 2X
B3-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B6-2
C2-3
C8-3

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2012-02-16
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3319	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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